

# Work Order ID 58514 - 2

May 10, 2010 7:18:39 AM

*SPI: +*



Page 1

Item ID: D2056  
Revision ID:  
Item Name: Bell Crank  
Start Date: 5/10/10  
Required Date: 5/11/10  
Reference:

Start Qty: 10.00  
Req'd Qty: 10.00

*8.00*

Accept



Setup Start



Stop



Cust Item ID:  
Customer:

Approvals:

Process Plan:  
QC:

*[Signature]*

Date:  
Date:

Tooling:

SPC (Y/N):

Date:  
Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2056	Rev B2								
100	BAND SAW	0.00							
	Bandsaw	0.00							
Jeaspa Bandsaw	Memo Cut blanks 2.80" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo Machine as per folio D2056 Tumble Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								

*mwp  
10/05/10*

*10*

*mwp  
10/05/10*

*8.0*

*mwp  
10/05/10*

*8.0*

W/O:			WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Item Name: Bell Crank  
Start Date: 5/10/10  
Required Date: 5/11/10  
Reference:

Accept



Setup Start



Stop



Start Qty: 10.00  
Req'd Qty: 10.00



Cust Item ID:  
Customer:

Approvals:

Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:

9:00AM  
320°F  
9:30AM

=> 14 10/05/13

8 8

8 BR 10-5-13.

8 8

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 58514

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Item ID: D2056

Accept



Setup Start



Revision ID:

Stop



Item Name: Bell Crank

Start Date: 5/10/10

Start Qty: 10.00



Cust Item ID:

Required Date: 5/11/10

Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8 BR 10-5-B.

170



Packaging

Packaging

Identify as per dwg & Stock Location: 006

0.00

Memo

0.00

PC 14/13 (8)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/17  
MF 10-5-14





# Picklist Print

May 10, 2010 3:10:47 PM

Page 1

Work Order ID: 58514



Parent Item: D2056

Parent Item Name: Bell Crank

Start Date: 10/05/2010

Required Date: 11/05/2010

Comments: IPP E 02.04.04 Added Rev.B2 NG

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased		No		100	f	20.2942	0.2375			



6061-T6 Bar 1.25 x 1.25



Location

MAT03

106259

110001

Loc Qty

20.29421053

10.0192105

10.275

Loc Code

MU-  
10/05/10

1.3866





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 58514
<b>Description:</b> Bell Crank		<b>Part Number:</b> D2056
<b>Inspection Dwg:</b> D2056	<b>Rev:</b> B2	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	.753	✓			
0.900	+/-0.010	.900	✓			
1.000	+/-0.010	.998	✓			
0.125	+/-0.010	.123	✓			
0.060	+/-0.010	.062	✓			
Ø0.191	+0.005/-0.001	Ø .191	✓			
0.362	+/-0.010	.362	✓			
0.750	+/-0.010	.754	✓			
0.385	+/-0.010	.385	✓			
Ø0.257	+0.006/-0.001	Ø .260	✓			
0.100	+/-0.010	.100	✓			
0.300	+/-0.010	.300	✓			
0.946	+/-0.010	.946	✓			
0.075	+/-0.010	.075	✓			
2.637	+/-0.010	2.637	✓			
0.375	+/-0.010	.374	✓			
Ø0.513-0.518	0.513 - 0.518	Ø .516	✓			
R0.450	+/-0.010	R .450	✓			
R0.125	+/-0.010	R .125	✓			
R0.200	+/-0.010	R .200	✓			
R0.550	+/-0.010	R .550	✓			
R0.263	+/-0.010	R .263	✓			

<b>Measured by:</b> mwA	<b>Audited by:</b> mw	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/05/10	<b>Date:</b> 10/05/13	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	
B	10.02.02	Dimensions revised	KJ	

125000

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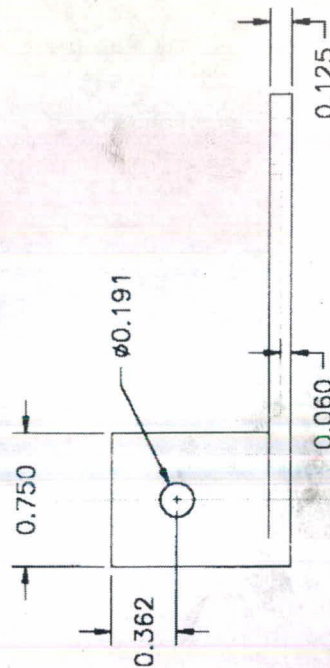
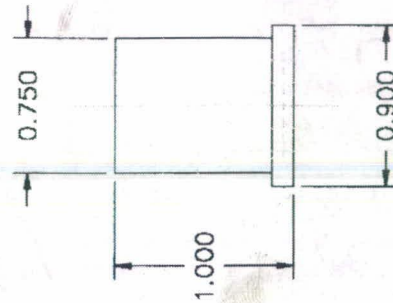
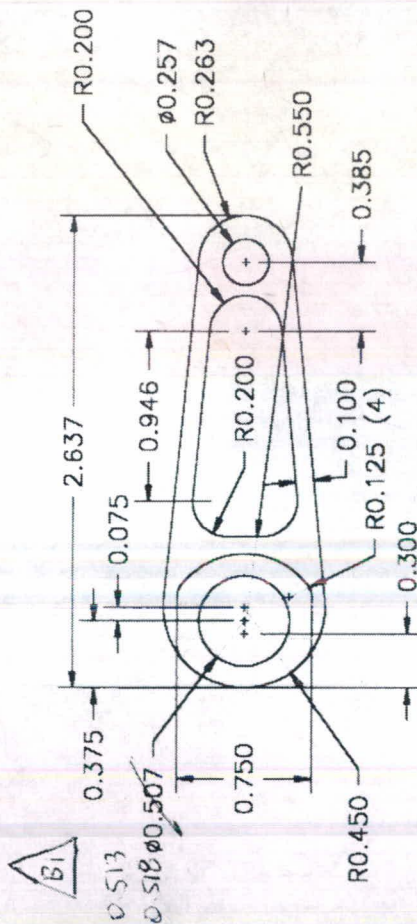
125000





DESIGN		DRAWN BY		DART AEROSPACE LTD	
B WILLIAMS		K HAND		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED		APPROVED		DRAWING NO.	
				D2056	
DATE		TITLE		REV. B	
92:03:13		BELL CRANK		SHEET 1 OF 1	
B	95:11:02	RE-DESIGN			
B1	 01.06.04	MODIFY HOLE SIZE, ADD FIC OPTION			
B2	 01.12.20	ADD NOTE ON TOLERANCES			

99-0429 HE



ACID ETCH & ALUMINE PER  
DWT QSE W/S 4.1

PUMPER W/HT BUREL STRIPPER  
(4357) PER DWT  
QSE W/S 4.3

61

MATERIAL: 6061-T6 (QQ-A-225/8)  
FINISH: ANODIZE (BLACK) OR  
TOLERANCES ARE PER DWT Q&I OR UNLESS OTHERWISE NOTED

